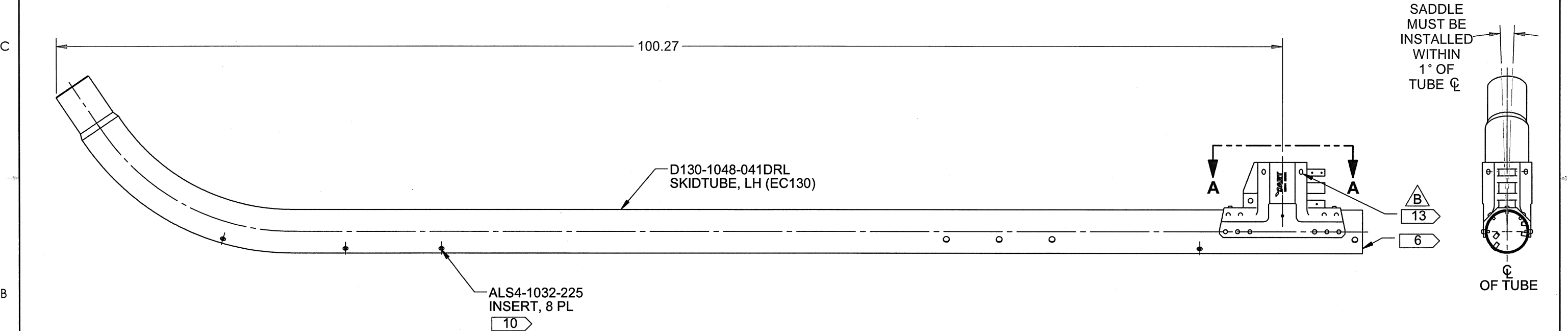
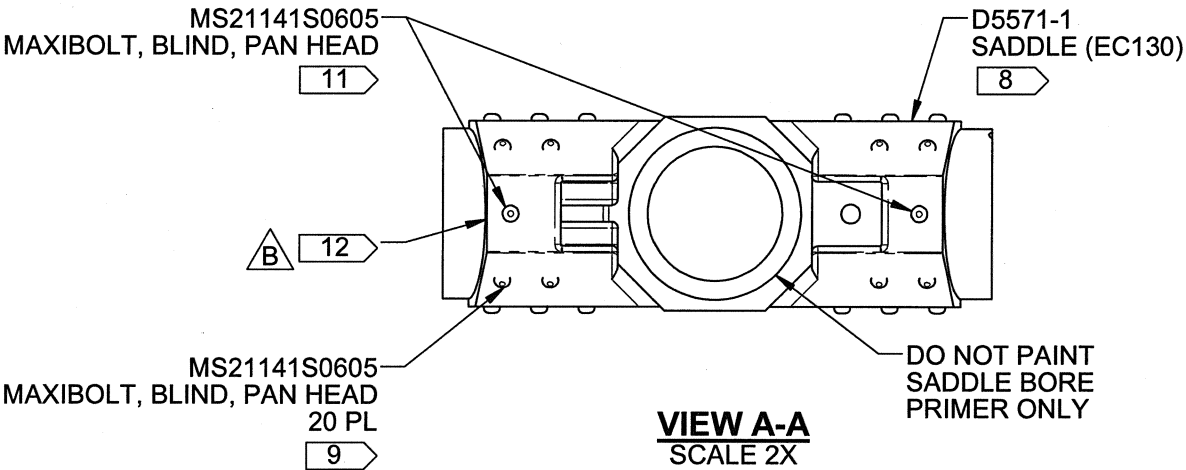


QTY -041	P/N	DESCRIPTION
X	D130-1048-041	SKIDTUBE ASSY, LH (EC130)
1	D130-1048-041DRL	SKIDTUBE, LH (EC130)
1	D5571-1	SADDLE (EC130)
22	MS21141S0605	MAXIBOLT, BLIND, PAN HEAD (CR7621S06-05)
8	ALS4-1032-225	INSERT



D130-1048-041 SKIDTUBE ASSY, LH (EC130)

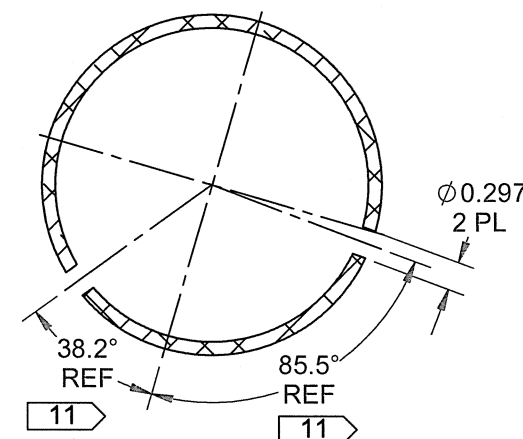
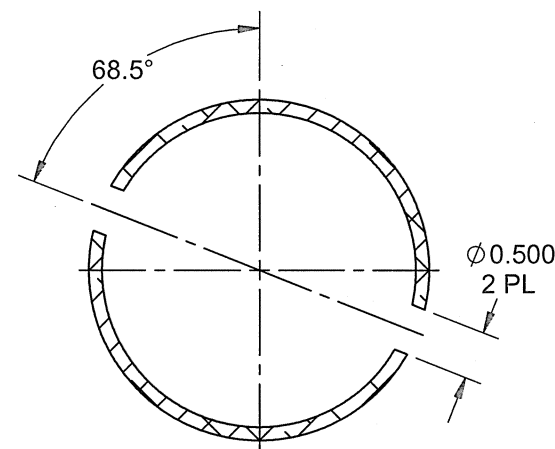
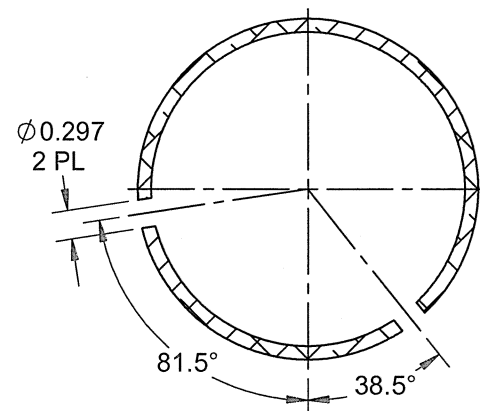
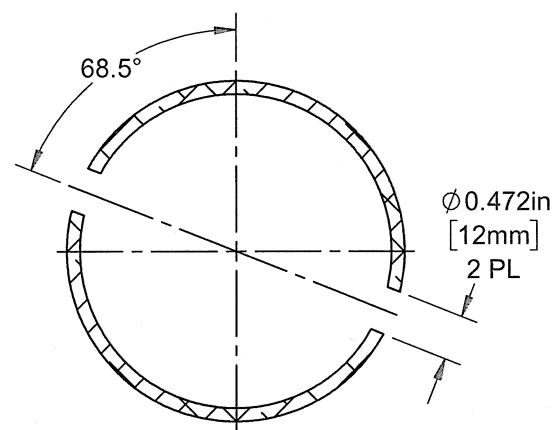
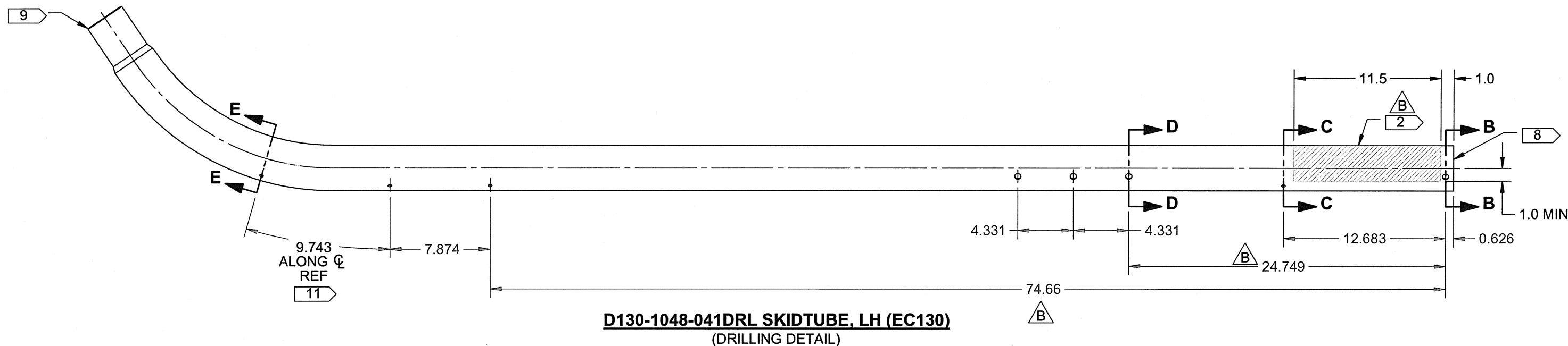
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) AFTER ASSEMBLY
PAINT OUTSIDE PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT) AFTER ASSEMBLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D130-1048-041" AND S/N PER DART QSI 044 6.4
ON INSIDE OF TUBE, MAX 0.5" FROM AFT END OF TUBE
- 7) WEIGHT: 20.29 lbs
- 8) SEAL FAYING SURFACE WITH PROSEAL 890 OR EQUIVALENT MIL-S-8802 CLASS A SEALANT
- 9) POSITION SADDLE AND TRANSFER DRILL $\phi 0.193$ HOLE PATTERN FROM SADDLE ONTO SKIDTUBE.
OPEN HOLES THRU SADDLE AND SKIDTUBE TO $\phi 0.199$ - $\phi 0.202$. TOUCH-UP HOLES WITH CHEMICAL FILM (ALODINE 1200)
PER MIL-DTL-5541. WET INSTALL MAXIBOLTS WITH PROSEAL 890 OR EQUIVALENT MIL-S-8802 CLASS A SEALANT
- 10) INSTALL ALS4 INSERTS IN EXISTING $\phi 0.297$ HOLES AFTER FINISH
- 11) TRANSFER DRILL $\phi 0.193$ HOLES FROM SADDLE TO SKIDTUBE. OPEN HOLES THRU SADDLE AND SKIDTUBE
TO $\phi 0.199$ - $\phi 0.202$. ENSURE CLEAN HOLES FOR GOOD ELECTRICAL BONDING. TOUCH-UP HOLES WITH
ELECTRICALLY CONDUCTIVE CHEMICAL FILM (ALODINE 600) PER MIL-DTL-5541. INSTALL MAXIBOLTS DRY (NO SEALANT)
- 12) FILLET SEAL ALL AROUND SADDLE WITH SIKAFLEX-241/-291 OR PROSEAL 890 OR EQUIVALENT MIL-S-8802 CLASS B SEALANT
- 13) MASK SADDLE HOLES BEFORE PRIME AND PAINT

RELEASED
2019 JUN 19 NO
ECN 19-625

APPROVED

B	REDRAWN BOTH SHEETS, D130-1048-041: ADDED PRIME TO FINISH NOTE, ADDED CLASS A SEALANT FOR FAY SEAL AND WET INSTALL MAXIBOLTS, INSTALL ALS 4 INSERTS AFTER FINISH, ADDED NOTE 12. D130-1048-041DRL: PRIME IN AREA SHOWN WAS PRIME INSIDE AND OUTSIDE, LPI AFTER DRILLING WAS PRIOR TO DRILLING, ADDED NOTE 12, REDIMENSION FROM BLADE HOLE INSTEAD OF TUBE END	ZF	18.12.31
A	NEW ISSUE	ZF	18.05.07
REV.	DESCRIPTION	BY	DATE
DESIGN	NO	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. B
MFG. APPR.	JFS	D130-1048-041	SHEET 1 OF 2
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	SKIDTUBE ASSY, LH (EC130)	NTS
DATE	18.12.31	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



NOTES:

- 1) MATERIAL: MAKE FROM D5611-1
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME AREA SHOWN (TO 1.0 BELOW CENTERLINE), PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 16.34 lbs
- 8) CHAMFER ID 0.06X0.06 WHERE INDICATED
- 9) CHAMFER OD 0.06X0.06 WHERE INDICATED
- 10) LIQUID PENETRANT INSPECT OUTSIDE SURFACE PER QSI 038 AFTER DRILLING.
- 11) LOCATE HOLES USING DRILLING JIG DT10431.
- 12) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE.
THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, WRINKLES OR DENTS.
DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

RELEASED
2019 JUN 19 No

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DESIGN	NO	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MW	DRAWING NO.	REV. B
MFG. APPR.	JFS	D130-1048-041	SHEET 2 OF 2
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	SKIDTUBE ASSY, LH (EC130)	NTS
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